Date: User: Tuesday, 05/08/2008 7:57:01 AM

Jean-Luc Menard

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

S.O. No. :

Drawing Name

: BUSHING

: D2570

: N/A

- D2570 REV B

Job Number **Estimate Number** : 40986 : 10175

P.O. Number

This Issue

: 05/08/2008

: NC

: 11 : 40197 **Previous Run**

Written By

Prsht Rev.

First Issue

Checked & Approved By

Comment

: Est E 02.08.29

Type

Re-format; Removed finishing; Material changeK

: MACHINED PARTS

est F 07.07.06 rev B dwg

EC

Drawing Number Project Number

Part Number

; B **Drawing Revision**

Material **Due Date**

: 12/08/2008

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

303 Round Bar 0.750

Description:

1.0

2.0

M303R0750

Comment: Qty.:

8.0955 f(s) 0.0810 f(s)/Unit Total:

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Batch MIOSJ2(1)

HARDINGE

Comment: HARDINGE CNC LATHE SMALL

Machine as per folio FA198

Deburr

3.0

4.0

5.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

QC8

SECOND CHECK



Comment: SECOND CHECK

PACKAGING 1

PACKAGING RESOURCE #1





Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Page 1

Form: rprocess

Tuesday, 05/08/2008 7:57:01 AM Date: User: Jean-Luc Menard

Process Sheet

Drawing Name: BUSHING

Job Number: 40986

Part Number: D2570

Job Number:

Seq. #:

Machine Or Operation:

Customer: CU-DAR001 Dart Helicopters Services

Description:

6.0

FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





DESIG	r PH	DRAWN BY	DART AEROSF HAWKESBURY, ONTAF	
CHEC	KED	APPROVED _	DRAWING NO.	REV. B
	献	91	D2570	SHEET 1 OF 1
DATE	-		TITLE	SCALE
07.0	04.17		BUSHING	1:1
Α		96.09.16	NEW ISSUE	
В		07.04.17	UPDATE NOTES	

- 0.800±0.010 0.060±0.005 -0.030 X 20° R0.010 (REF)

w/0 409 86 Ø0.750 Ø0.257^{+0.005}_{-0.000} Ø0.425^{+0.000}_{-0.002}

D2570 BUSHING

D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH: NONE

- ALL DIMENSIONS ARE INCHES 3)
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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DART AEROSPACE LTD	Work Order:	40986
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	798"				
0.060	+/-0.005	,060"				
R0.010	+0.010/-0.000	Pi,0/0"				
Ø0.425	+0.000/-0.002	\$ 424"				
Ø0.257	+0.006/-0.001	Ø, 259°				
Ø0.750	+/-0.010	Ø 744°				
0.030 x 20°	+/-0.010	(035°×)	*			

Measured by: J.F.	Audited by:	H. A/ml	Prototype Approval:	N/A
Date: 08/08/06	Date:	08/08/08	Date:	

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	ĶJ/RF	
В		Tolerance for Ø0.425 changed	KJ/RF	
C		Dimensions updated per Dwg Rev. B	KJ/JLM 1/A	
D	08.07.23	The state of the s	KJ/DD SH	\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\